

R 66 test 50LBS/F

Work Order ID 139762

139762

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Monday, December 07, 2015 10:58:26 AM

Item ID: D3969-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spring (Basket Lid)
 Start Date: 12/9/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/9/2015 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: CL Date: DEC 07 2015 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3969	C

100 0.00

100

Purchasing Memo 0.00 CL DEC 07 2015 1

Purchasing
 Issue P/O: 30676
 Order as per Dwg D3969
 Possible supplier: LS Technologies
 part#: SSA4/6-122-315-133N
 Material release note is required

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging Memo 0.00 1X SP15-12-09

Packaging
 ***Measure compression only at
 5mm on gas spring***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	***Measure compression only at 5mm on gas spring***								
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

① 15-12-11 PD
 tested at 50lbs.
 for testing only.
 on R66 basket.

① 15-12-11 PD

20151216

Picklist Print

Page 1

Monday, December 07, 2015 10:58:24 AM

Work Order ID: 139762

139762

Parent Item: D3969-5

D3969-5

Parent Item Name: Spring (Basket Lid)

Start Date: 12/9/2015

Required Date: 12/9/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.16 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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SSA4/6-122-315-133N

Purchased

No

Each

0.0000

1

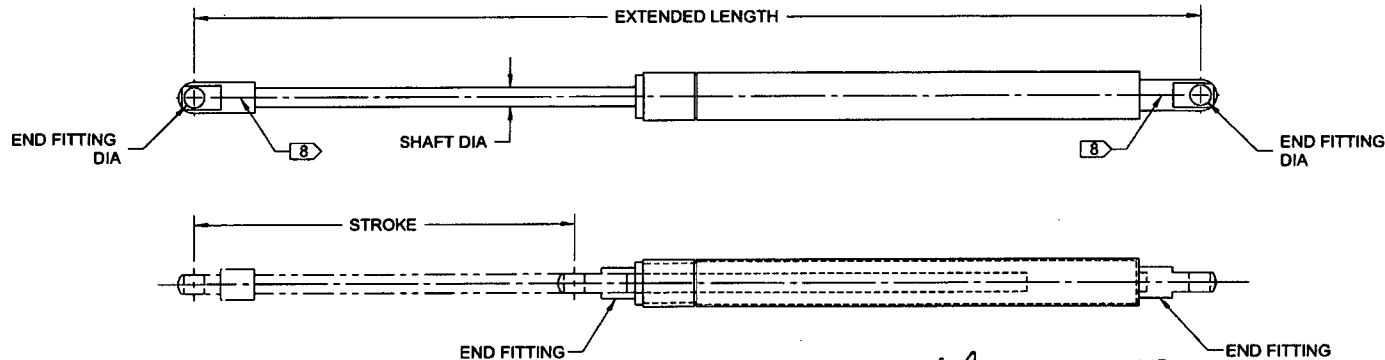
SSA4/6-122-315-133N

**

Gas Spring

1X Sp 15-12-09.

SPECIFICATION CONTROL DRAWING



D3969-X SPRING

DEC 07 2015
W/O: 139762

DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	120/4.70	315/12.40	6/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	120/4.70	315/12.40	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	120/4.70	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: SEE CHART
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE CHART
- 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

C	REDRAWN IN SW. ADDED -3 & -5: ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 80.0 lbs)	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID). NOTE 8 ADDED	AJS	09.11.10
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	N/A	D3969	SHEET 1 OF 1
APPROVED	AM	TITLE	SCALE
DE APPR.	#	BASKET LID SPRING	NTS
DATE	10.03.04	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30676**

Purchase Order Date 12/7/2015

PO Print Date 12/7/2015

Page Number 1 of 2

Order From :

VC-LST0001

Ship To : DART AEROSPACE LTD

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 306 683 5000

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	SSA4/6-122-315-133N AS PER DWG D3969 REV. C B139757	Gas Spring	12/10/2015 Yes 12/10/2015		2.00 Each	\$65.00	\$130.00
Line Total:							\$130.00
2	SSA4/6-122-315-133N AS PER DWG D3969 REV. C B139762 NOTE: THE PART NEED TO BE AT 50 LBS/F ONLY	Gas Spring	12/10/2015 Yes 12/10/2015		1.00 Each	\$65.00	\$65.00
Line Total:							\$65.00

SP15-12-09.

PO Instructions: Fedex Acc#151793240

Note:

12/7/2015

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

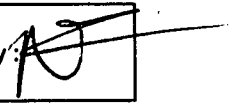
P.O. No.	Date	Invoice #
30676	12/08/2015	14144

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
12/08/2015	Fed-Ex	

Qty	Description
2	D3969-5 B139757 Stainless Gas Spring (SSA4/6-122-315-133N)
1	D3969- B1397612 Stainless Gas Spring (SSA4/6-122-315-225N) 50 Lb Force
Shipping Via FED EX Tracking #	
SP15-12-09	

Order checked by: 



LS Technologies Inc

314 Jessop Ave

Saskatoon, SK, S7N 1Y6

Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Conformance

Dec 08, 2015

This is to certify that the parts listed below meets specifications as required by your order.

2 Units : D3969-5 B139757 Stainless Gas Spring (SSA4/8-122-310-133N)

1 Unit: D3969- B139762 Stainless Gas Spring (SSA4/6-122-315-225N) 50 Lb Force

Country of Manufacture : Canada

Date of Manufacture : Oct 2015

This product is ROHS compliant.

Purchase Order # 30676

Inv# 14144

SP15-12-09.

L S Technologies Inc Canada

Nolan Fehr
President